

Date: Tuesday, 27/03/2007 7:38:41 AM  
 User: Linda Lacelle









## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET
<b>Job Number</b> : 31301	
<b>Estimate Number</b> : 11181	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D32941
<b>This Issue</b> : 27/03/2007 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D3294 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 31301	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : _____	<b>Due Date</b> : 03/04/2007 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3 .080 sheet
  <p><b>Comment:</b> Qty.: 2.1072 sf(s)/Unit Total : 21.0725 sf(s)            Material: 2024-T3 (QQ-A-250/4) 0.080" thick            (M2024T3S.080)            Identify for D3294-1            Batch: <i>m102838</i> <i>ml 07 03 28</i> (10)</p>		
2.0	WATER JET	FLOW WATER JET
  <p><b>Comment:</b> FLOW WATER JET            1-Cut as per Dwg D3294            Dwg Rev: <i>A1</i> <i>ml 07 03 29</i> (10)            Prog Rev: <i>A1</i>            2-Deburr if necessary <i>SAD 07/04/01</i></p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
  <p><b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <i>ml 07 03 29</i> (10)</p>		
4.0	QC8	SECOND CHECK
  <p><b>Comment:</b> SECOND CHECK <i>07/04/02</i> (8)</p>		

Date: Tuesday, 27/03/2007 7:38:41 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31301

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

SAD 07/04/02 (8)

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE  
Form as per Dwg D3294

SB 07/04/11 8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-11

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

07-04-12 (8)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M1102361  
M-L 07/04/12

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

07/4/13 (8)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

07/4/13 (8)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/13 (8)

Job Completion



07-04-13

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: BRACKET
<b>Job Number</b>	: 31301		
<b>Estimate Number</b>	: 11181		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D32941
<b>This Issue</b>	: 3/19/2007 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D3294 REV A1
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b>	: A1
<b>Previous Run</b>	:	<b>Material</b>	:
<b>Written By</b>	: _____	<b>Due Date</b>	: 3/30/2007 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: _____ <i>[Signature]</i> 07.03.20		
<b>Comment</b>	: Est A 04.08.24    New issue KJ/JLM		

## Job Number:



Seq. #:	Machine Or Operation:	Description :
1	1000	1000
2	1000	1000
3	1000	1000
4	1000	1000
5	1000	1000
6	1000	1000
7	1000	1000
8	1000	1000
9	1000	1000
10	1000	1000
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94	1000	1000
95	1000	1000
96	1000	1000
97	1000	1000
98	1000	1000
99	1000	1000
100	1000	1000

1.0 M2024T3S080 2024-T3 .080 sheet



Comment: Qty.: 2.1072 sf(s)/Unit Total : 21.0725 sf(s)  
Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
(M2024T3S.080)  
Identify for D3294-1  
Batch: \_\_\_\_\_

2.0 ~~SHEAR~~ ~~SHEAR~~



Comment: SHEAR  
Cut blank: 1.950" x 0.700" grain along 1.950"  
Note: To be made in multiples of 10

3.0 ~~HAAS~~ ~~WATERLOO~~ HAAS CNC VERTICAL MACHINING #1



**Comment:** HAAS CNC VERTICAL MACHINING #1  
Machine as per Folio FA445 and Dwg D3294  
Stack of 10  
Identify as D3294-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:38:14 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31301

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE  
Form as per Dwg D3294

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



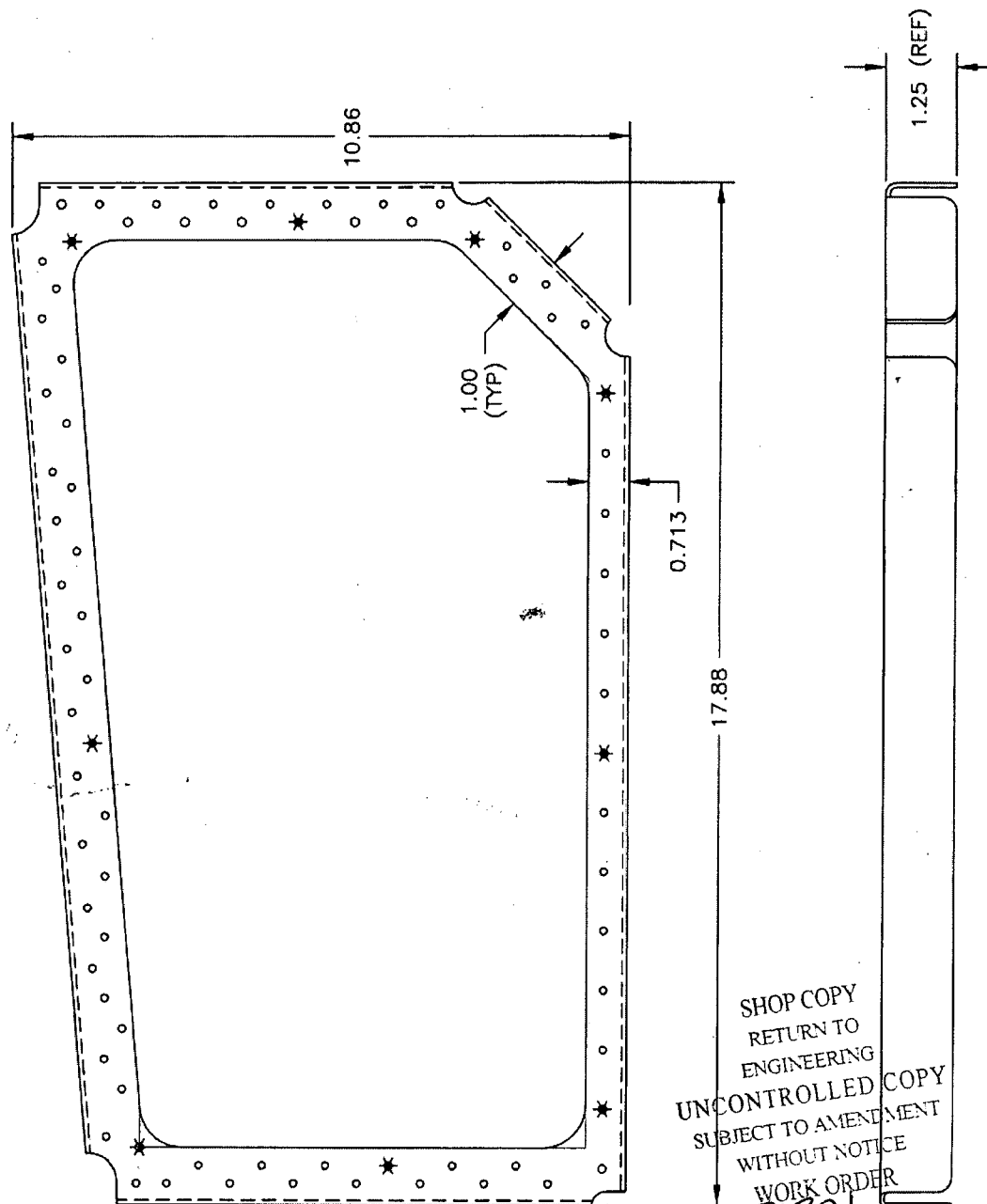


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	TH	APPROVED	TH	DRAWING NO. D3294	REV. A SHEET 1 OF 2
DATE	04.06.28			TITLE BRACKET	SCALE 1:3
A	04.06.28			NEW ISSUE	
AI	UR	05.06.13			12.97 WAS 13.63, AS MANUFACTURED

RELEASED  
04.07.12

D3294-1 BRACKET

- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
- 2) CHECK PER TEMPLATE D3294-1T1
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 5) USE MINIMUM BEND RADIUS OF 0.188"
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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WORK ORDER  
NO 31301

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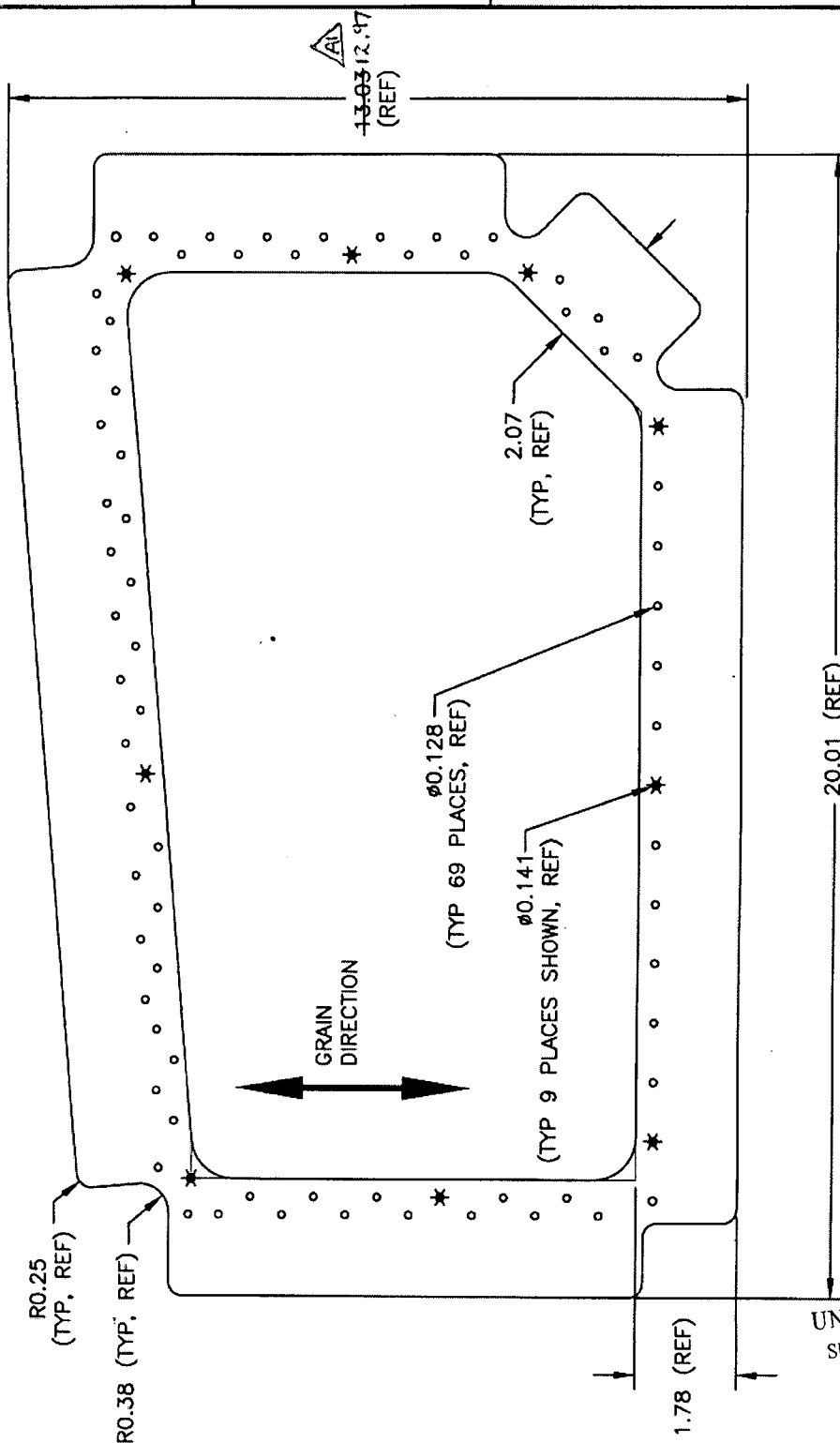




DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3294</b>	REV. A SHEET 2 OF 2
DATE <b>04.06.28</b>		TITLE <b>BRACKET</b>	SCALE <b>1:3</b>

**D3294-1 FLAT PATTERN**

RELEASED  
04.07.12



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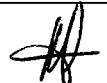

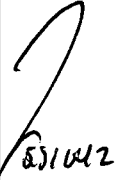



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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.04.02	2	One <del>Ø0.128</del> HOLE					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/04/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.04.02	2	One <del>Ø0.128</del> HOLE DRILLED <del>Ø0.154</del> ON QTY(5) PARTS.		PARTS ACCEPTABLE. PROBLEM WAS WITH DUG & FLAT PATTERN.	N/A	 07/04/02	 07.04.02	 07/04/02
07/04/02	2	2 part scrap the Ø.128" hole are over size at Ø.135" out of tol	 07/04/02	-destroy	SB 07/04/02	 07/04/02	 07/04/02	 07/04/02

NOTE: Date & initial all entries